

Date: Tuesday, 12/11/2007 10:25:58 AM
 User: BOSS Admin

Process Sheet

| | | | |
|-----------------------|---|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : PATIENT STOP |
| Job Number | : 36243 | | |
| Estimate Number | : 11490 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D2492 |
| This Issue | : 12/11/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D2492 REV F |
| Prsht Rev. | : NC | Project Number | : <i>N/A</i> |
| First Issue | : 12/10/2007 Type : MACHINED PARTS | Drawing Revision | : F |
| Previous Run | : 25271 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> 07-12-11 | Due Date | : 12/24/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | 16 Um: Each |
| Comment | : Est. E 00.06.26 Removed P/O for powder coat EC Est Rev.F Now 6061-T6. 06-06-23 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.9140 sf(s)/Unit Total: 30.6247 sf(s)
 6061-T6 .080 Sheet
 Material: 6061-T6 0.080" thick
 (M6061T62S.080)
 Batch *106320* *HB 07-12-11*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2492
 Dwg Rev: *F* *HB 07-12-11*
 Prog Rev: *F*
 2-Deburr if necessary *HB 07-12-11*



| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

counts
5 07-12-11 *(16)*

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Deburr
 Form using Jig DT2492B

SAD 08-01-03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP

Job Number: 36243

Part Number: D2492

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08 (16)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(alodine) M-1
acid etch: Alodine
M 106379
BP 08-01-08
08/01/08 (16X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1
08/01/08 (16X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 189

AS 08/01/08 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(16)
08/01/08

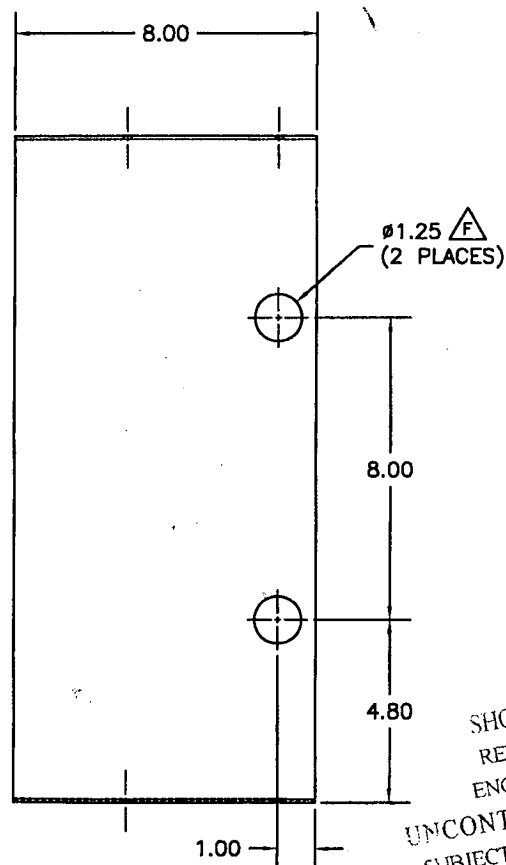
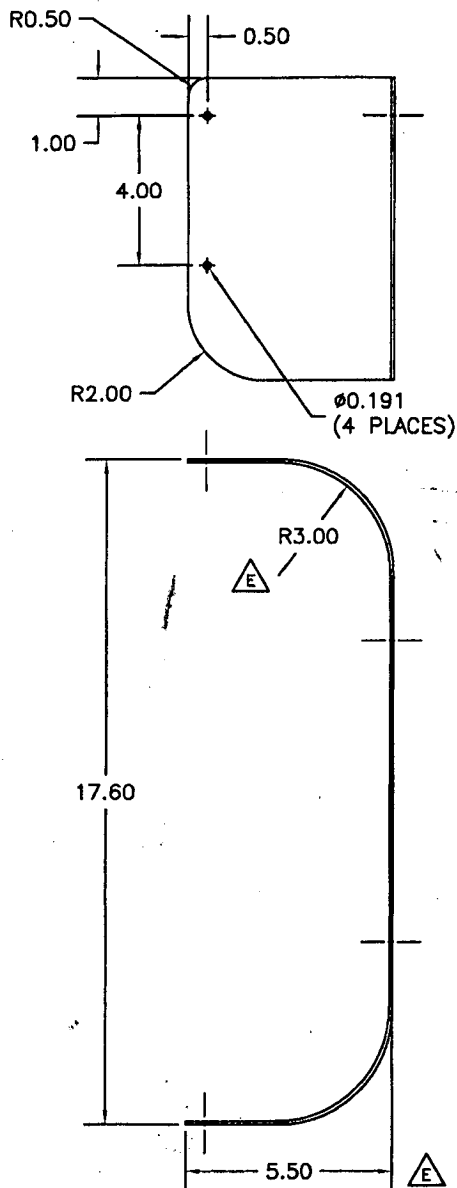
Job Completion



U 08-01-09

DART

| | | | |
|------------------|--------------------------------|--|------------------------|
| DESIGN KE | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED <i>[Signature]</i> | DRAWING NO. D2492 | REV. F SHEET 1 OF 1 |
| DATE 06.09.14 | TITLE PATIENT STOP | | SCALE 1:5 |
| A | 95.10.24 | NEW ISSUE | |
| B | 96.02.28 | MINOR CHANGES | |
| C | 97.07.14 | CHANGED MATERIAL AND FINISH | |
| D | 98.05.11 | R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION | |
| E | 06.05.30 | ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00 | |
| F | 06.09.14 | Ø1.25 WAS Ø1.020 | |

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36243

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